



LACKPOXI HOLDING PRIMER

PRODUCT DESCRIPTION: Holding bicomponent epoxy polyamine iron oxide primer. Quick drying, excellent adhesion, easy application and excellent performance.

RECOMMENDED USES: Medium and heavy industry: Shipyards and mechanical metal.

CERTIFICATIONS AND APPROVAL: This product, when supplied to comply with the RoHs Directive (Restriction of Certain Hazardous Substances) has the letter R in its description.

PACKAGING:	Component	Content	Package	Unit of measurement
	Component A	20	20	L
	Component B	20	20	L

CHARACTERISTICS: **Color:** Red oxide
Gloss: Matte
VOC content: 600 g/l
Volume solid: 32 ± 2% (ISO 3233).

Shelf-Life: 12 months at 25°C.
Thickness per coat (dry): 20 µm –30 µm
Theoretical coverage: 12,8 m²/l without dilution in the thickness of 25 µm dry. Without considering loss factors in application.

Resistance to dry heat: Maximum temperature 120 °C . The product retains its physical and chemical properties up to the temperature of 120 °C however, variations in the coating color and gloss may occur from 60 °C.

Drying:	15°C	20°C	25°C	30°C	40°C
Touch:	14 minutes	12 minutes	10 minutes	5 minutes	3 minutes
Handling:	40 minutes	35 minutes	30 minutes	25 minutes	20 minutes
Final:	240 hours	192 hours	168 hours	168 hours	144 hours
Pot Life	15 hours	14 hours	12 hours	10 hours	8 hours

Overcoating Drying:	15°C	20°C	25°C	30°C	40°C
Min	12 hours	10 hours	8 hours	6 hours	6 hours
Max	6 months	6 months	6 months	6 months	6 months.

SURFACE PREPARATION The performance of this product depends on the degree of surface preparation.

The accumulated dirt must be removed using a dry brush, clean and dry cloth, compressed air blow, vacuum cleaner and/or with the combination of such items, and the soluble salts must be removed through wash with a great quantity of fresh water, preferably with low pressure (up to 5,000 psi) according to SSPC-SP 12/NACE No. 5.

For new works, it is necessary to treat spatter and weld seams, damaged areas, sharp edges and corners using abrasive blasting grade Sa2½ or SSPC-SP10, visual standard ISO 8501-1. In cases where the above practice is not possible, consult the Technical Department of Weg Tintas for the use of Wegpoxi Edge Retention.

Surface treatment through Abrasive Blasting process

Execute the abrasive blasting to near white metal, Sa 2 ½ grade of the ISO 8501-1 visual standard (A Sa 2 ½, B Sa 2 ½, C Sa 2 ½ and D Sa 2 ½) or according to SSPC-SP 10/NACE No. 2, SSPC-VIS 1 visual standard (A SP 10, B SP 10, C SP 10, D SP 10, G1 SP 10, G2 SP 10, G3 SP 10).

Inspect the newly blasted surface observing the presence of surface flaws that could become apparent after this stage, adopting appropriate actions to mitigate such defects through grinding, weld filling and/or

epoxy putty.

It is recommended a roughness profile between 40 and 85 µm.

Maintenance and repair

NOTE: Observe the product overcoating interval to apply the next coat. In case the maximum overcoating interval has been exceeded, it is necessary to manually/mechanically sand the surface to break the gloss of the previous coat and clean the sanding residues so as to provide better adhesion between the coats.

For further information, consult WEG Technical Department.

PREPARATION FOR APPLICATION

Mixture

Homogenize the contents of each component with mechanical or pneumatic stirring (A and B). Check there are no sediment settled at the bottom of the package. Add component B to component A, at the recommended proportion (volume), under stirring, until complete homogenization, observing the mixing ratio.

Mixing ratio (Volume)

1 A X 1 B.

Diluent Epoxy diluent 3005

Dilution

Depending on the application method, dilute at most 5%

Only add the diluent after complete mixing of components A + B.

Do not dilute with solvents that are not allowed by local legislation and do not exceed the recommended dilution percentage.

Excessive dilution of the coating may affect the formation and aspect of the film and not allow to reach the specified thickness.

Pot life of the mixture (25°C)

12 h

Check the pot life values in the Characteristics field.

In places with higher temperature and air relative humidity, the pot life will decrease.

In hot areas, we recommend consulting WEG Technical Department.

APPLICATION FORMS

The data below is a guide, and similar equipment may be used.

Changes in nozzle sizes and pressures may be necessary to improve spraying characteristics. Before application, check the equipment and its components are clean and in best condition. Purge the compressed air line to prevent contamination of the coating.

After mixing 2-pack products, if there are stops in the application, and pot life is exceeded (the coating shows variation in fluidity) it can no longer be diluted for further application.

Recoat all sharp edges, cracks and weld beads with a brush to prevent premature failures in these areas.

Conventional gun:

Gun:	JGA 502/3 Devilbiss or equivalent
Fluid nozzle:	EX
Air cap:	704
Atomization pressure:	60 - 65 psi
Pressure in the tank:	10 - 20 psi
Dilution:	5%

Airless Gun:

Use Airless:	Use at least pump 60: 1
Fluid pressure:	2700 – 3000 psi
Hose:	¼" internal diameter
Nozzle:	0,015" - 0,021"

Filter: Mesh 60

Brush:

Only recommended for touch up small areas or stripe coat (screws, nuts, weld and sharp edges). Use a brush 75 to 100 mm wide for larger surfaces and 25 to 38 mm for touch up.

Roller:

Not recommended.

NOTE: For application by cutting it may be necessary to apply two or more passes to obtain a uniform layer according to the film thickness recommended by others.

Cleaning the equipment:

Epoxy diluent 3005

Do not leave catalyzed product in contact with the equipment used in the application, because the coating will vary in fluidity at temperatures above specified in the pot life and will cure faster, making the cleaning difficult.

Clean all equipment immediately after use.

NOTE:

PERFORMANCE IN THE APPLICATION

For a good performance of the product, we recommend following the directions below:

Product not recommended for painting the interior of tanks

Do not apply the product after the pot life has expired.

We recommend coating only if the surface temperature is at least 3 °C above the dew point temperature.

The temperature of the substrate, the weather and environmental conditions during the application and during the curing of the product, and the thickness of the coat may interfere in the product drying time.

Epoxy systems may have longer curing time when exposed to low temperatures. For temperatures below 10 °C, consult WEG Technical Department.

For better application properties, the coating temperature should be between 21 - 27 °C prior to the mixing and application.

It should not be applied under adverse conditions, such as air relative humidity (RH) above 85%, as changes in color and appearance may occur.

On newly painted surfaces in direct contact with water during the curing process, localized stains may occur with changes in their color (more visible in dark colors), delay in curing and compromised product performance.

Variations in color, aspect and gloss (more noticeable in dark colors) may occur, as well as delay in curing and low coating performance, when applied during periods of high air relative humidity, rainy days, low temperatures or drying the coating outdoor.

Epoxy-based products are known to have excellent anti-corrosion properties and low resistance to sunlight exposure. In situations of exposure of the film to the weather, over time it will present a loss of gloss known as chalking and its shade will change as a consequence. Remember that even undergoing such chalking, the film anti-corrosion protection is not impaired.

For further information, consult WEG Technical Department.

SAFETY PRECAUTIONS

Product developed for industrial use intended for handling by qualified professionals.

Please read carefully all the information contained in the MSDS of this product, available at: www.weg.net.

Store in a covered, well-ventilated area. Keep the container tightly closed and away from sources of heat or ignition.

Use only in well-ventilated areas avoiding the accumulation of flammable vapors. Keep the product away from heat and sources of ignition.

Do not inhale mists / vapors / aerosols generated during handling and / or application.

Wear protective gloves / protective clothing / eye protection / face protection.

Avoid release this product and its packaging, as well as materials used during handling and application in the environment.

NOTE:

The information contained in this technical datasheet is based upon the experience and knowledge acquired in the field by the technical team of WEG.

If using the product without previous inquiry to WEG Coating concerning its suitability for the customer's intended purpose, the customer is aware that the use shall be its exclusive responsibility, WEG not being

responsible for behavior, safety, suitability or durability of the product.

Some information contained in this datasheet are estimated, and can undergo variances arising from factors outside the manufacturer's control. Thus, WEG does not guarantee and does not assume any responsibility regarding the yield, performance or any other material or personal damage resulting from the incorrect use of the products concerned or the information contained in this Technical datasheet.

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